

Work Order ID 151975

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151975

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Item ID: D2282-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: T Assembly
Start Date: 10/14/2016 Start Qty: ~~30.00~~ ***30*** 19 ~~2m~~
Required Date: 11/3/2016 Req'd Qty: ~~30.00~~ ***30*** 19 ~~2m~~
Cust Item ID:
Reference: Customer:

Approvals: Process Plan: DAS 21 9-89 Date: OCT 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100 Large Fab 0.00
100
Large Fab Memo 0.70
Large Fab 1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration.as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod M13442

19 12/6/11-2

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
QC Memo 0.00
Quality Control

19 NOV 09 2016 DAS 24 9-89

120 Small Fab 0.00
120
Small Fab Memo 0.30
Small Fab Tumble

19 12/6/11/11

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Revision ID: Stop ***NS2***
Item Name: T Assembly
Start Date: 10/14/2016 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 11/3/2016 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.10			DAS 30 9-89	19			NOV 11 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo LOCATION : GA	0.00 0.05			DAS 30 9-89	(19)			NOV 11 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.50			DAS 21 9-89				NOV 11 2016
					DAS 21 9-89				NOV 11 2016

Picklist Print

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Parent Item: D2282-041

D2282-041

Parent Item Name: T Assembly

Start Date: 10/14/2016

Required Date: 11/3/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3

Manufactured No

100

Each

67.0000

1

30

D2282-3

EL 10/11/16

Tube

Location

Loc Qty

Loc Code

WA002

67

150974

67

19

D2282-5

Manufactured No

100

Each

74.0000

1

30

D2282-5

EL 10/11/16

Tube

Location

Loc Qty

Loc Code

WA002

74

149967

24

151157

50

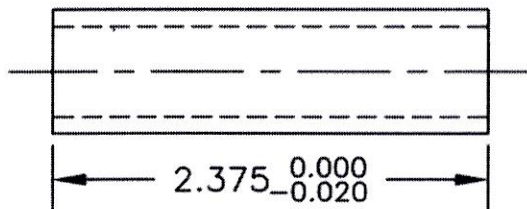
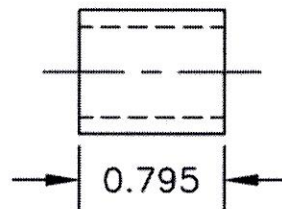
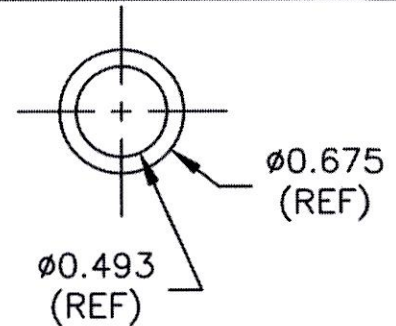
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DART

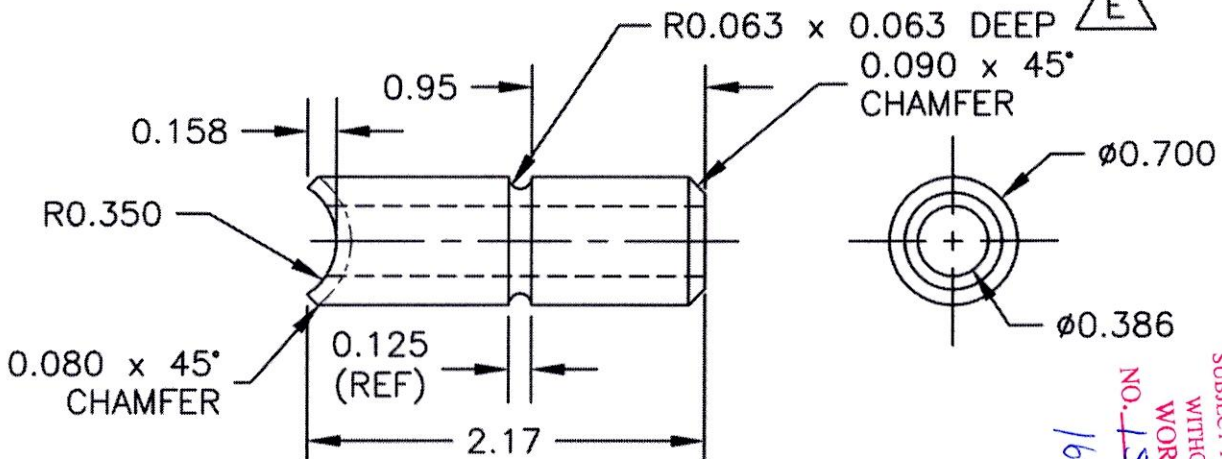
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

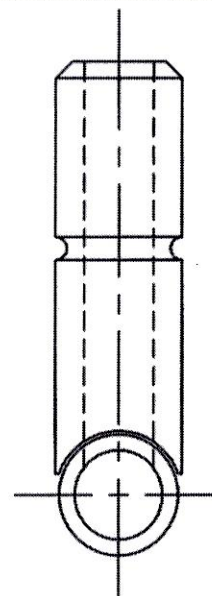
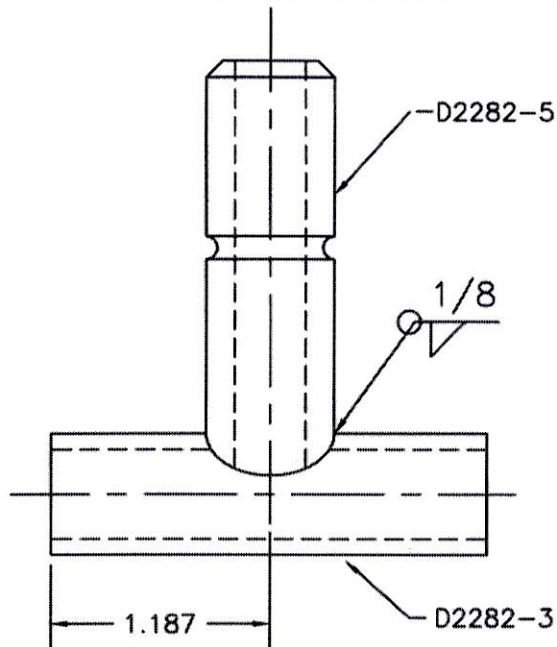
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16-10-17
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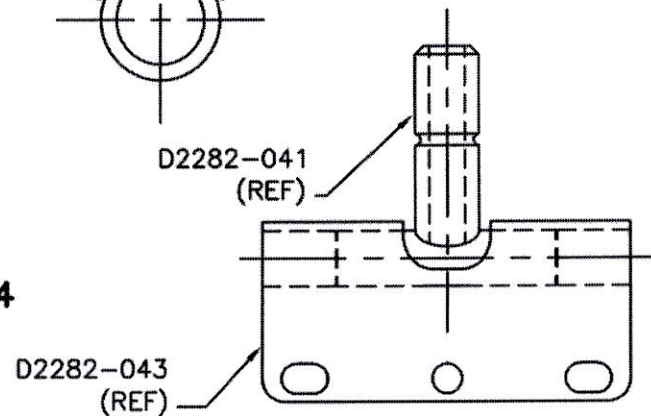
DART

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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

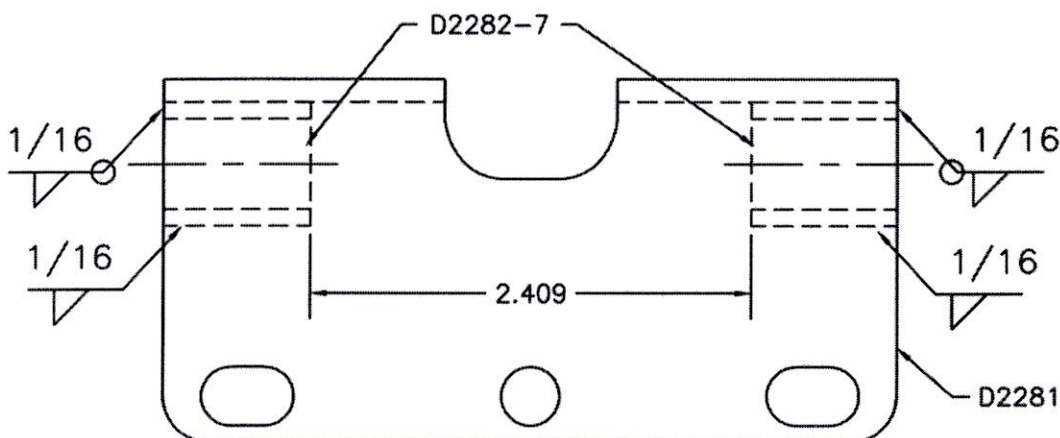


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[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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